made from a forging, two stationary bushings being inserted in the top and one in the bottom. As the jig and work weighed about twelve pounds, it was hard for the workmen to be constantly lifting the jig and turning it over for the operation on the other side; therefore, two pieces of steel were machined to a radius and attached to the jig between the four feet on the side opposite the leaf. With the aid of these rockers, the jig is easily turned over from one side to the other. They do not interfere in any way with the working parts, and when changing

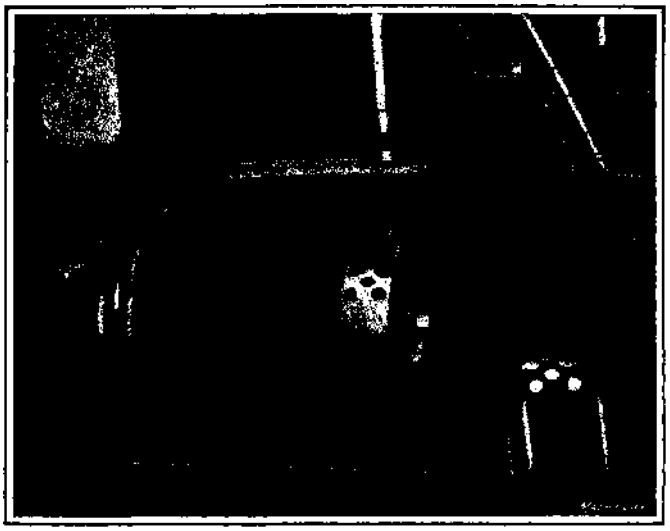

Fig. 11. Brill Jig designed for Rapid Indexing

work, the jig is supported by the rockers. In this way, the jig is always on the drilling table, and there is less likelihood of the operator letting it fall to the ground or throwing it down and snapping the bushing or legs, which are hardened to glass hardness. In addition, the operator does not have to work so hard a&d the production is considerably increased.

Drill Jig designed for Rapid Indexing. — The necessity for a drill jig of the indexing type was brought about by a certain design of motorcycle drive pulley. This pulley is of the flat-belt, flanged type, having cork inserts over its entire periphery.